



US009273688B2

(12) **United States Patent**
Sasaki et al.

(10) **Patent No.:** **US 9,273,688 B2**
(45) **Date of Patent:** **Mar. 1, 2016**

(54) **PUMP ROTOR AND INTERNAL GEAR PUMP USING THE SAME**

(71) Applicant: **SUMITOMO ELECTRIC SINTERED ALLOY, LTD.**, Okayama (JP)

(72) Inventors: **Harumitsu Sasaki**, Itami (JP); **Kentaro Yoshida**, Itami (JP)

(73) Assignee: **SUMITOMO ELECTRIC SINTERED ALLOY, LTD.**, Okayama (JP)

(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 85 days.

(21) Appl. No.: **14/345,395**

(22) PCT Filed: **Feb. 28, 2013**

(86) PCT No.: **PCT/JP2013/055271**

§ 371 (c)(1),

(2) Date: **Mar. 17, 2014**

(87) PCT Pub. No.: **WO2013/157306**

PCT Pub. Date: **Oct. 24, 2013**

(65) **Prior Publication Data**

US 2014/0341769 A1 Nov. 20, 2014

(30) **Foreign Application Priority Data**

Apr. 17, 2012 (JP) 2012-093767

(51) **Int. Cl.**
F03C 2/00 (2006.01)
F03C 4/00 (2006.01)

(Continued)

(52) **U.S. Cl.**
CPC . **F04C 2/10** (2013.01); **F01C 1/084** (2013.01);
F01C 1/103 (2013.01); **F04C 2/084** (2013.01);
F04C 2/102 (2013.01); **F04C 2270/13**
(2013.01); **F04C 2270/16** (2013.01)

(58) **Field of Classification Search**

CPC F04C 2/102; F04C 2/084; F04C 2/086;
F04C 2/10; F04C 1/084; F04C 1/086; F01C
1/103; F01C 1/084; F01C 1/086

USPC 418/166, 171, 61.3, 150
See application file for complete search history.

(56) **References Cited**

U.S. PATENT DOCUMENTS

5,772,419 A 6/1998 Hansen et al.
2010/0209276 A1* 8/2010 Uozumi et al. 418/150
2012/0177525 A1* 7/2012 Uozumi et al. 418/150

FOREIGN PATENT DOCUMENTS

CN 1442615 A 9/2003
CN 1816694 A 8/2006

(Continued)

OTHER PUBLICATIONS

European Office Action for related European Application No.
13777471.7—1608 dated Jun. 16, 2015, 6 pages.

(Continued)

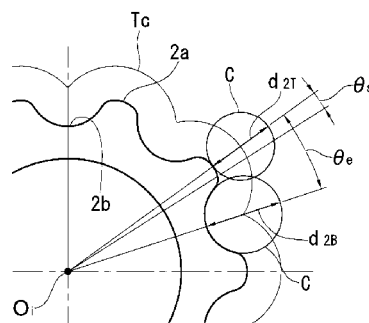
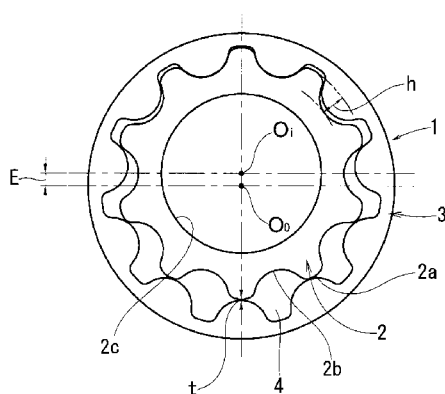
Primary Examiner — Theresa Trieu

(74) *Attorney, Agent, or Firm* — Ditthavong & Steiner, P.C.

(57) **ABSTRACT**

A tooth profile of an inner rotor 2 is formed by an envelope of a group of circular arcs of a locus circle C having a center on a trochoidal curve TC. The envelope of the group of circular arcs is formed by rolling a rolling circle having a predetermined diameter along a base circle without slipping and drawing the trochoidal curve TC based on a point distant from the center of the rolling circle by a distance equivalent to an amount of eccentricity between the two rotors. A diameter d_2 of the locus circle C is constant until one point between an addendum point and a dedendum point of the inner rotor and changes from the one point such that a diameter d_{2B} at the dedendum point becomes larger than a diameter d_{2T} at the addendum point of the inner rotor.

4 Claims, 4 Drawing Sheets



(51)	Int. Cl.		EP	0779432	A1	6/1997
	F04C 2/00	(2006.01)	EP	2206923	A1	7/2010
	F04C 2/10	(2006.01)	JP	61-201892	A	9/1986
	F04C 15/00	(2006.01)	JP	2008138601	A	6/2008
	F04C 2/08	(2006.01)	JP	2010-151068	A	7/2010
	F01C 1/10	(2006.01)	WO	2005005835	A1	1/2005
	F01C 1/08	(2006.01)	WO	2008111270	A1	9/2008
			WO	2010016473	A1	2/2010

OTHER PUBLICATIONS

(56) **References Cited**

FOREIGN PATENT DOCUMENTS

CN	101627209	A	1/2010
CN	101821510	A	9/2010

International Search Report of corresponding International Application PCT/JP2013/055271, dated May 21, 2013, 1 page.
Chinese Office Action for related Chinese Patent Application No. 201380003081.4 dated Sep. 25, 2015, 17 Pages.

* cited by examiner

FIG. 1

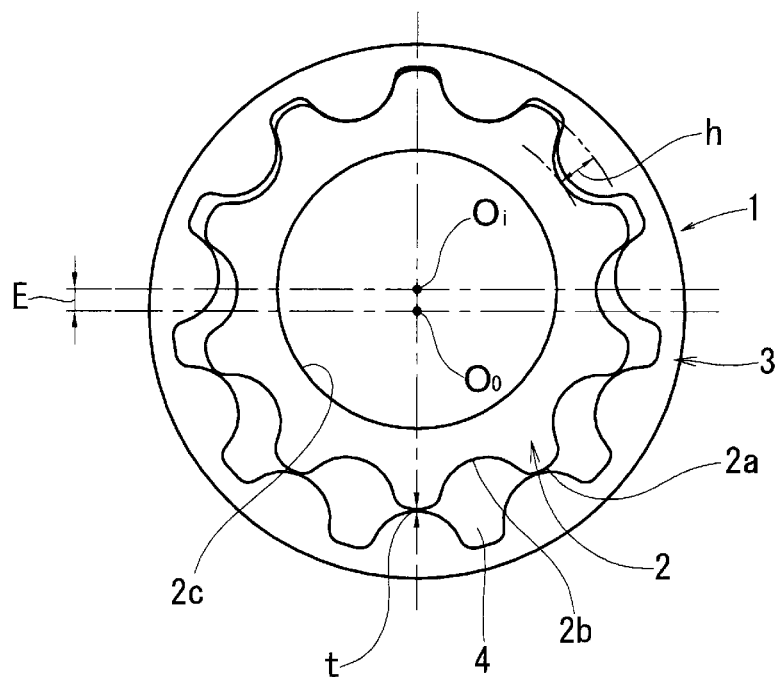


FIG. 2

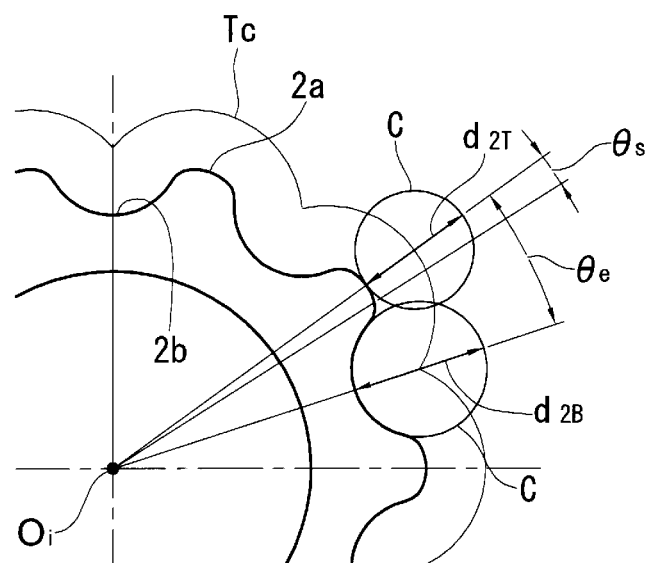


FIG. 3

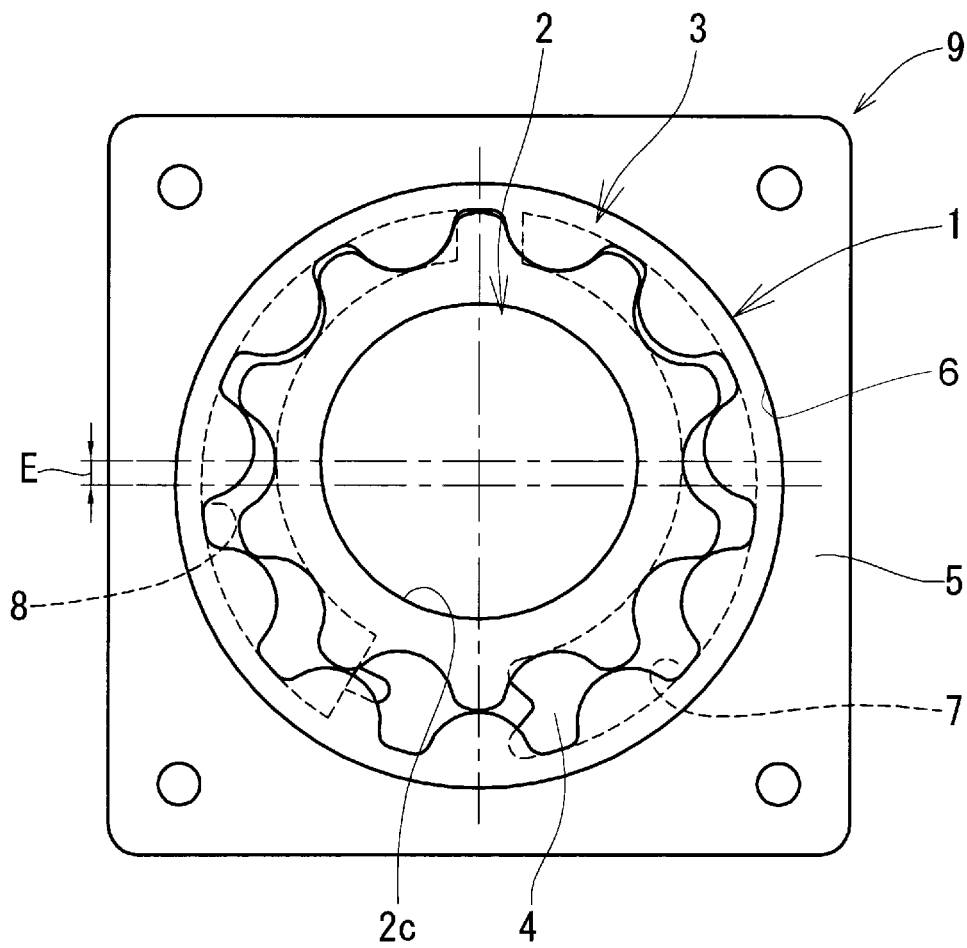


FIG. 4

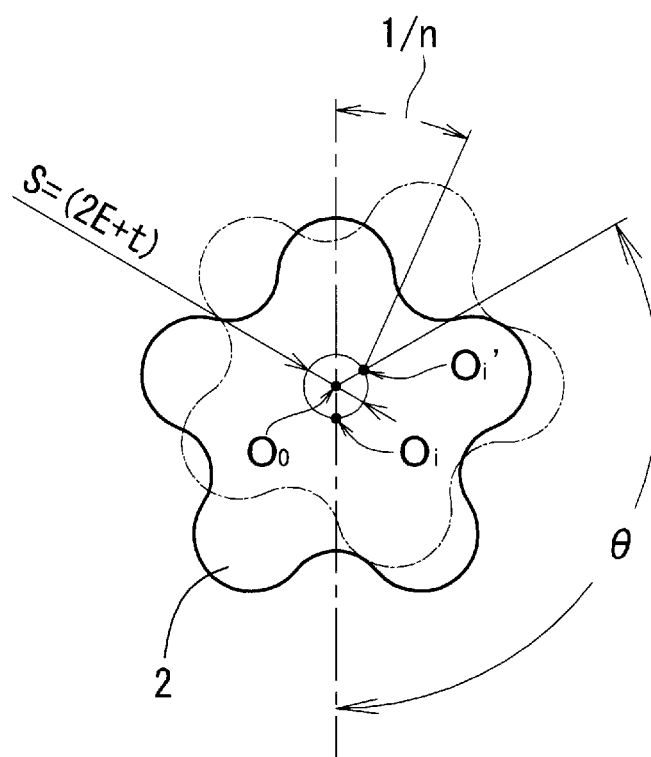
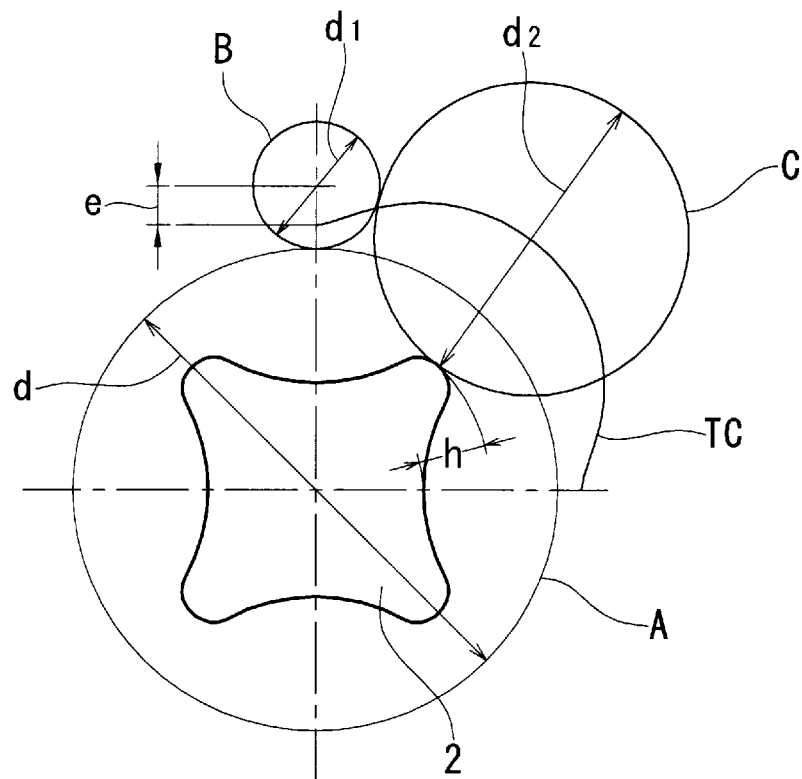


FIG. 5

1

PUMP ROTOR AND INTERNAL GEAR PUMP USING THE SAME

TECHNICAL FIELD

The present invention relates to a pump rotor formed by combining an inner rotor (external gear) and an outer rotor (internal gear) between which a difference in the number of teeth is one, and to an internal gear pump formed by fitting the pump rotor within a housing.

BACKGROUND ART

Internal gear pumps are used as, for example, pumps for lubricating engines and automatic transmissions (AT) in vehicles. One known type of such an internal gear pump is formed by combining an inner rotor and an outer rotor, between which a difference in the number of teeth is one, and disposing the rotors eccentrically relative to each other. Furthermore, in another known pump of this type, the tooth profile of the rotors is formed by using a trochoidal curve, which is known for good volume efficiency, low noise, and low drive torque.

A tooth profile formed by using this trochoidal curve is formed in the following manner. First, as shown in FIG. 5, a rolling circle B rolls along a base circle A without slipping, and a trochoidal curve TC is drawn by a locus of a point on a radius distant from the center of the rolling circle B by a distance e (=amount of eccentricity between rotation centers of the inner rotor and the outer rotor). Then, the tooth profile of the inner rotor 2 is formed by an envelope of a group of circular arcs of a locus circle C having a fixed diameter and whose center is located on the trochoidal curve TC (also see Patent Literature 1 below).

In a pump having a tooth profile using such a trochoidal curve, an amount E of eccentricity between the center of the inner rotor and the center of the outer rotor is regulated for ensuring the face width and for designing the tooth profile. Therefore, an increase in the tooth height is limited, making it difficult to fulfill demands for increasing the discharge rate. The present applicant has made a proposition in Patent Literature 2 below in which the tooth height can be freely set in a pump rotor of the aforementioned type.

CITATION LIST

Patent Literature

PTL 1: Japanese Unexamined Patent Application Publication No. 61-201892

PTL 2: Japanese Unexamined Patent Application Publication No. 2010-151068

SUMMARY OF INVENTION

Technical Problem

In the internal gear pump having the rotors in Patent Literature 2, the capacity of a pump chamber formed between the teeth of the inner rotor and the outer rotor can be increased by increasing the tooth height of the rotors. Although this achieves high discharge performance, noise caused by, for example, gear rattling increases.

The inner rotor whose tooth profile is formed based on the method according to claim 2 in the same literature has narrow addenda. Thus, addendum abrasion tends to occur easily.

2

An object of this invention is to reduce noise and suppress addendum abrasion in the pump proposed in Patent Literature 2 by devising the method for forming the tooth profile of the inner rotor.

Solution to Problem

In order to achieve the aforementioned object, in an internal gear pump according to the present invention that is formed by combining an inner rotor having n teeth and an outer rotor having (n+1) teeth, the rotors are formed in the following manner.

Specifically, when a rolling circle having a diameter d_1 is rolled along a base circle having a diameter d without slipping and a trochoidal curve is drawn by a point distant from a center of the rolling circle by a distance e, a tooth profile of the inner rotor is formed by an envelope of a group of circular arcs of a locus circle having a diameter d_2 and having a center on the trochoidal curve. The diameter d_2 of the locus circle is constant until one point between an addendum point and a dedendum point of the inner rotor and changes from the one point such that a diameter d_{2B} at the dedendum point becomes larger than a diameter d_{2T} at the addendum point.

The diameter d_2 of the locus circle (C) may change so as to satisfy the following expression:

$$d_2\theta = d_{2T} + (d_{2B} - d_{2T}) \times (\theta - \theta_s) / (\theta_e - \theta_s) \quad \text{Expression (1)}$$

where θ denotes an angle between the addendum point and the center of the locus circle,

$d_2\theta$ denotes a diameter of the locus circle C at the angle θ ,

d_{2T} denotes a diameter of the locus circle C at the addendum point of the inner rotor,

d_{2B} denotes a diameter of the locus circle C at the dedendum point of the inner rotor,

θ_e denotes an angle between the addendum point and the dedendum point of the inner rotor and is determined from $180^\circ/n$, and

θ_s denotes an angle from the addendum point of the inner rotor to a position where the diameter d_2 of the locus circle C begins to change ($\theta_e \neq \theta_s$).

A ratio of a diameter d_{2T} of the locus circle C at the addendum point of the inner rotor to a diameter d_{2B} at the dedendum point preferably satisfies a condition $d_{2T}/d_{2B} > 0.9$.

Furthermore, the angle θ_s is preferably set between 5% and 40% of an angle θ_e between the addendum point and the dedendum point of the inner rotor.

The present invention also provides an internal gear pump formed by accommodating a pump rotor within a rotor chamber provided in a housing. The pump rotor is formed by combining an inner rotor having the aforementioned tooth profile with an outer rotor whose tooth profile is formed by an envelope of a group of tooth-profile curves of the inner rotor, the envelope of the group of tooth-profile curves being formed by revolving a center of the inner rotor around a circle having a diameter $(2E+t)$ and coaxial with a center of the outer rotor, and rotating the inner rotor $1/n$ times while the center of the inner rotor makes one revolution around the circle.

In the above description, E denotes an amount of eccentricity between the inner rotor and the outer rotor, t denotes a maximum clearance (tip clearance) between addenda of the outer rotor and the inner rotor pressed against the outer rotor, and n denotes the number of teeth of the inner rotor. The amount E of eccentricity between the inner rotor and the outer rotor is as follows: $E = e + (d_{2B} - d_{2T})/4$.

The present invention can reduce noise and suppress addendum abrasion by devising the method for forming the tooth profile of the inner rotor.

BRIEF DESCRIPTION OF DRAWINGS

FIG. 1 is an end-surface diagram illustrating an example of a pump rotor according to this invention.

FIG. 2 illustrates a method for forming a tooth profile of an inner rotor according to the invention.

FIG. 3 is an end-surface diagram illustrating an internal gear pump equipped with the pump rotor in FIG. 1 in a state where a cover of a housing is removed therefrom.

FIG. 4 illustrates a method for forming a tooth profile of an outer rotor.

FIG. 5 is a diagram explaining a method for forming a tooth profile using a trochoidal curve.

DESCRIPTION OF EMBODIMENTS

An embodiment of a pump rotor 1 according to this invention will be described below with reference to FIGS. 1 to 3. The pump rotor 1 shown in FIG. 1 is formed by combining an inner rotor 2 having n teeth ($n=10$ in the drawings) and an outer rotor 3 having $(n+1)$ teeth. Reference character 2a denotes an addendum point of the inner rotor 2, and reference character 2b denotes a dedendum point of the inner rotor 2. The inner rotor 2 has a shaft hole 2c in the center thereof.

The inner rotor 2 has a tooth profile that is formed by an envelope described with reference to FIG. 5. Specifically, a rolling circle B having a diameter d_1 rolls along a base circle A having a diameter d without slipping, and a trochoidal curve TC is drawn by a point distant from the center of this rolling circle B by a distance e . Then, the tooth profile is formed by an envelope of a group of circular arcs of a locus circle C having a diameter d_2 and whose center is located on the trochoidal curve TC. In the following description, the distance e from the center of the rolling circle B will be referred to as a tentative amount of eccentricity between the inner rotor 2 and the outer rotor 3.

As shown in FIG. 2, with regard to the locus circle C used for drawing the envelope, a diameter d_{2T} at the addendum point 2a of the inner rotor 2 and a diameter d_{2B} at the dedendum point 2b are different from each other. In detail, the diameter of the locus circle C gradually increases from the addendum point 2a toward the dedendum point 2b of the inner rotor 2.

Accordingly, a tooth height h of the inner rotor 2 is larger than the tooth height of teeth formed based on the method in FIG. 5. As a result, the capacity of a pump chamber (chamber) 4 formed between the teeth of the inner rotor 2 and the outer rotor 3 increases, so that the pump discharge rate increases.

The diameter d_2 of the locus circle C changes as expressed by the following expression (1):

$$d_2\theta = d_{2T} + (d_{2B} - d_{2T}) \times (\theta - \theta_s) / (\theta_e - \theta_s) \quad \text{Expression (1)}$$

where θ denotes an angle between the addendum point and the center of the locus circle,

$d_2\theta$ denotes a diameter of the locus circle C at the angle θ ,

d_{2T} denotes a diameter of the locus circle C at the addendum point of the inner rotor,

d_{2B} denotes a diameter of the locus circle C at the dedendum point of the inner rotor,

θ_e denotes an angle between the addendum point and the dedendum point of the inner rotor and is determined from $180^\circ/n$, and

θ_s denotes an angle from the addendum point of the inner rotor to a position where the diameter d_2 of the locus circle C begins to change ($\theta_e \neq \theta_s$).

With regard to a ratio of the diameter d_{2T} at the addendum point of the locus circle C to the diameter d_{2B} at the dedendum point (d_{2T}/d_{2B}), a smaller value thereof allows for a larger tooth height. However, since this leads to louder gear rattling noise, the ratio may be set such that the condition $d_{2T}/d_{2B} > 0.9$ is satisfied.

Furthermore, in the tooth profile formed based on the method described in claim 2 of Patent Literature 2 mentioned above, the face width of the inner rotor 2 decreases with decreasing ratio of d_{2T}/d_{2B} . In the rotor according to this invention, the diameter d_2 of the locus circle C based on Expression (1) changes from a position displaced from the addendum by a certain angle. Thus, even if the ratio of d_{2T}/d_{2B} is small to a certain extent, a narrow addendum is suppressed.

In this case, as described above, the angle θ_s from the addendum to the position where the diameter d_2 of the locus circle C begins to change may be set between 5% and 40% of the angle θ_e between the addendum point and the dedendum point of the inner rotor (referred to as "half tooth angle" hereinafter), or more preferably, between about 10% and 20% thereof.

By setting the angle θ_s to 5% or higher of the half tooth angle θ_e , an advantage of suppressing addendum abrasion can be satisfactorily achieved. Furthermore, by setting the angle θ_s to 40% or lower of the half tooth angle θ_e , an advantage of suppressing a rapid increase in the clearance at each addendum does not need to be sacrificed. In view of the balance between the addendum-abrasion suppression effect and the noise prevention effect, an appropriate numerical value may be selected for the angle θ_s from a preferred range.

The outer rotor 3 used has one tooth more than the inner rotor 2. The tooth profile of the outer rotor 3 is formed as shown in FIG. 4. Specifically, a center O_i of the inner rotor 2 first makes one revolution around a circle S having a diameter $(2E+t)$ and coaxial with a center O_o of the outer rotor 3. Then, while the center O_i of the inner rotor makes one revolution around the circle S, the inner rotor rotates $1/n$ times. An envelope of a group of tooth-profile curves of the inner rotor 2 formed in this manner serves as the tooth profile of the outer rotor 3.

In this case, E denotes an amount of eccentricity between the inner rotor and the outer rotor, t denotes a maximum clearance (=tip clearance) between the addenda of the outer rotor and the inner rotor pressed against the outer rotor, and n denotes the number of teeth of the inner rotor. The relationship between the amount E of eccentricity and the tentative amount e of eccentricity is as follows: $E = e + (d_{2B} - d_{2T})/4$.

As shown in FIG. 3, when corner sections at the opposite ends, in the rotor rotating direction, of each dedendum of the outer rotor 3 are widened in a direction away from the corresponding addendum of the inner rotor 2, a gap is formed between the addendum of the inner rotor and the dedendum of the outer rotor. This prevents gear rattling between the inner rotor 2 and the outer rotor 3, thereby further enhancing the noise reduction effect.

The pump rotor 1 is formed by combining the inner rotor 2 and the outer rotor 3 described above and disposing them eccentrically relative to each other. Then, as shown in FIG. 3, the pump rotor 1 is accommodated within a rotor chamber 6 of a pump housing 5 having an intake port 7 and a discharge port 8, whereby an internal gear pump 9 is formed.

5

In the internal gear pump **9**, a drive shaft (not shown) is fitted through the shaft hole **2c** of the inner rotor **2**, and the inner rotor **2** rotates by receiving a drive force from the drive shaft. In this case, the outer rotor **3** is driven and rotated. This rotation causes the capacity of the pump chamber **4** formed between the two rotors to increase or decrease so that a liquid, such as oil, is injected or discharged.

EXAMPLES

Example 1

An internal gear pump having the specifications shown in Table I is designed. In sample 1 in Table I, the diameter of the locus circle C for forming the tooth profile of the inner rotor is changed from the addendum as in the rotor according to Patent Literature 2 (i.e., $\theta_s=0^\circ$), and the aforementioned ratio of d_{2T}/d_{2B} is set to 0.9. Moreover, the tentative amount e of eccentricity (i.e., amount of eccentricity in design) is slightly smaller than that in sample 2.

In sample 2, $d_{2T}/d_{2B}=0.99$, and the angle from the addendum to the position where the diameter of the locus circle begins to change is set such that $\theta_s=2.5^\circ$.

The tooth profile of the outer rotor to be combined with the inner rotor is formed based on the method described with reference to FIG. 4 by using the inner rotor serving as the combination partner.

TABLE I

Sample number	1	2
Number of teeth of inner rotor	10	10
Number of teeth of outer rotor	11	11
Outside diameter (mm) of outer rotor	85	85
Dedendum diameter (mm) of outer rotor	76.9	76.9
Addendum diameter (mm) of outer rotor	73.9	73.9
Addendum diameter (mm) of inner rotor	70.3	70.3
Dedendum diameter (mm) of inner rotor	57.3	57.3
Amount E of eccentricity (mm)	3.25	3.25
Diameter (mm) of base circle A for forming tooth profile	69.2	71.6
Diameter (mm) of rolling circle B for forming tooth profile	6.92	7.16
Diameter d_{2T} (mm) of locus circle C at addendum point of inner rotor	12.38	14.89
Diameter d_{2B} (mm) of locus circle C at dedendum point of inner rotor	13.84	15.01
d_{2T}/d_{2B}	0.90	0.99
Tentative amount e of eccentricity (mm)	3.105	3.212
Angle θ_s ($^\circ$) from addendum point of inner rotor to position where diameter d_2 of locus circle C begins to change	0	2.5
Angle θ_e ($^\circ$) between addendum point and dedendum point of inner rotor	18	18
θ_s/θ_e (%)	0	14

Next, each sample is fitted into a housing so as to form a pump. The pump is driven under the following conditions to check the occurrence of noise. The test results obtained are shown in Table II and Table III.

Test Conditions

Rotation speed of pump: 1000 rpm to 4000 rpm

Oil used: Engine oil SAE 30

6

Oil temperature: 80° C.

Discharge pressure: 0.5 MPa and 1.0 MPa

TABLE II

Discharge pressure: 0.5 MPa (unit: dB)		
Sample number	1	2
1,000 rpm	77.4	77.3
2,000 rpm	80.6	79.4
3,000 rpm	81.7	78.8
4,000 rpm	85.1	82.4

TABLE III

Discharge pressure: 1.0 MPa (unit: dB)		
Sample number	1	2
1,000 rpm	81.1	74.3
2,000 rpm	86.1	78.7
3,000 rpm	83.3	81.3
4,000 rpm	85.1	84.0

From these test results, it can be confirmed that it is advantageous to set the diameter of the locus circle, for forming the tooth profile of the inner rotor, constant until one point between the addendum point and the dedendum point of the inner rotor and then to change the diameter of the locus circle such that the diameter d_{2B} at the dedendum point becomes larger than the diameter d_{2T} at the addendum point. With this configuration, for example, a rapid increase in tooth-to-tooth clearance is suppressed, whereby noise is reduced.

Furthermore, when forming the tooth profile of the inner rotor, the diameter of the locus circle is made to change from a position displaced from the addendum point by a certain angle. Thus, the addenda of the inner rotor are thicker than those of the rotor according to Patent Literature 2 described above, thereby suppressing addendum abrasion.

Example 2

Next, an internal gear rotor with an inner rotor **2** having eight teeth and an outer rotor **3** having nine teeth is designed. The design specifications are shown in Table IV.

In each sample, $d_{2T}/d_{2B}=0.983$. The angle θ_s from the addendum point of the inner rotor to the position where the diameter d_2 of the locus circle C begins to change is changed.

The tooth profile of the outer rotor to be combined with the inner rotor is formed based on the method described with reference to FIG. 4 by using the inner rotor serving as the combination partner.

TABLE IV

Sample number	3	4	5
Number of teeth of inner rotor	8	8	8
Number of teeth of outer rotor	9	9	9
Outside diameter (mm) of outer rotor	$\phi 90$	$\phi 90$	$\phi 90$
Dedendum diameter (mm) of outer rotor	82.4	82.4	82.4

TABLE IV-continued

Sample number	3	4	5
Addendum diameter (mm) of outer rotor	65.7	65.7	65.7
Addendum diameter (mm) of inner rotor	74.0	74.0	74.0
Dedendum diameter (mm) of inner rotor	57.3	57.3	57.3
Amount E of eccentricity (mm)	4.18	4.18	4.18
Diameter (mm) of base circle A for forming tooth profile	74.88	74.88	74.88
Diameter (mm) of rolling circle B for forming tooth profile	9.36	9.36	9.36
Diameter d_{2T} (mm) of locus circle C at addendum point of inner rotor	18.41	18.41	18.41
Diameter d_{2B} (mm) of locus circle C at dedendum point of inner rotor	18.73	18.73	18.73
d_{2T}/d_{2B}	0.983	0.983	0.983
Tentative amount e of eccentricity (mm)	4.1	4.1	4.1
Angle θ_s (°) from addendum point of inner rotor to position where diameter d_2 of locus circle C begins to change	0	3	9
Angle θ_e (°) between addendum point and dedendum point of inner rotor	22.5	22.5	22.5
θ_s/θ_e (%)	0	13	40

Next, each sample is fitted into a housing so as to form a pump. The pump is driven under the following conditions to check the occurrence of noise. The test results obtained are shown in Table V.

Test Conditions

Rotation speed of pump: 1000 rpm to 4000 rpm
 Oil used: Engine oil SAE 30
 Oil temperature: 80° C.
 Discharge pressure: 0.5 MPa

TABLE V

Discharge pressure: 0.5 MPa (unit dB)			
Sample number	3	4	5
1,000 rpm	78.9	78.8	78.3
2,000 rpm	82.2	81.0	80.4
3,000 rpm	83.3	80.4	79.7
4,000 rpm	86.8	84.0	83.2

From these test results, it can be confirmed that it is advantageous to set the diameter of the locus circle, for forming the tooth profile of the inner rotor, constant until one point between the addendum point and the dedendum point of the inner rotor and then to change the diameter of the locus circle such that the diameter d_{2B} at the dedendum point becomes larger than the diameter d_{2T} at the addendum point. With this configuration, for example, a rapid increase in the tooth-to-tooth clearance is suppressed, whereby noise is reduced.

The embodiment disclosed this time is merely an example in all aspects and should not be considered as being limitative. The scope of this invention is intended to include all modifications that are defined within the scope of the claims or within a scope equivalent to the scope of the claims.

REFERENCE SIGNS LIST

1 pump rotor
 2 inner rotor
 2a addendum point
 2b dedendum point
 2c shaft hole
 3 outer rotor
 4 pump chamber
 5 pump housing
 6 rotor chamber

7 intake port
 8 discharge port
 9 internal gear pump
 A base circle
 B rolling circle
 C locus circle
 TC trochoidal curve
 S circle having diameter (2E+t)
 d diameter of base circle A
 d_1 diameter of rolling circle B
 d_2 diameter of locus circle C
 h tooth height of inner rotor
 O_i center of inner rotor
 O_o center of outer rotor
 e tentative amount of eccentricity between inner rotor and outer rotor
 E amount of eccentricity between inner rotor and outer rotor
 t maximum clearance (=tip clearance) between teeth of outer rotor and inner rotor pressed against outer rotor
 n number of teeth of inner rotor
 θ angle between addendum point and center of locus circle
 $d_2\theta$ diameter of locus circle C at angle θ
 d_{2T} diameter of locus circle C at addendum point of inner rotor
 d_{2B} diameter of locus circle C at dedendum point of inner rotor
 θ_e angle between addendum point and dedendum point of inner rotor and determined from $180^\circ/n$
 θ_s angle from addendum point of inner rotor to position where diameter d_2 of locus circle C begins to change ($\theta_e \neq \theta_s$)
 The invention claimed is:
 1. An internal-gear-pump rotor comprising:
 an inner rotor having n gear teeth and an outer rotor having (n+1) gear teeth,
 wherein when a rolling circle having a diameter d_1 is rolled along a base circle having a diameter d without slipping and a trochoidal curve is drawn by a point distant from a center of the rolling circle by a distance e, a tooth profile of the inner rotor is formed by an envelope of a group of circular arcs of a locus circle (C) having a diameter d_2 and having a center on the trochoidal curve,
 wherein the diameter d_2 of the locus circle C is constant until one point between an addendum point and a dedendum point of the inner rotor and changes from the one

9

point such that a diameter d_{2B} at the dedendum point becomes larger than a diameter d_{2T} at the addendum point, and wherein the diameter d_2 of the locus circle C changes as expressed by Expression (1) below:

$$d_2\theta = d_{2T} + (d_{2B} - d_{2T}) \times (\theta - \theta_s) / (\theta_e - \theta_s) \quad \text{Expression (1)}$$

where θ denotes an angle between the addendum point and the center of the locus circle,

$d_2\theta$ denotes a diameter of the locus circle C at the angle θ , d_{2T} denotes a diameter of the locus circle C at the addendum point of the inner rotor,

d_{2B} denotes a diameter of the locus circle C at the dedendum point of the inner rotor,

θ_e denotes an angle between the addendum point and the dedendum point of the inner rotor and is determined from $180^\circ/n$, and

θ_s denotes an angle from the addendum point of the inner rotor to a position where the diameter d_2 of the locus circle C begins to change ($\theta_e \neq \theta_s$).

2. The pump rotor according to claim 1, wherein an angle θ_s from the addendum point to a position where the diameter d_2 of the locus circle C begins to change is set between 5% and 40% of an angle θ_e between the addendum point and the dedendum point of the inner rotor.

10

3. The pump rotor according to claim 1, wherein a ratio of a diameter d_{2T} of the locus circle C at the addendum point of the inner rotor to a diameter d_{2B} at the dedendum point satisfies a condition $d_{2T}/d_{2B} > 0.9$.

4. An internal gear pump formed by accommodating a pump rotor within a rotor chamber provided in a housing, the pump rotor being formed by combining an inner rotor having a tooth profile according to claim 1 with an outer rotor whose tooth profile is formed by an envelope of a group of tooth-profile curves of the inner rotor, the envelope of the group of tooth-profile curves being formed by revolving a center of the inner rotor around a circle having a diameter $(2E+t)$ and coaxial with a center of the outer rotor, and rotating the inner rotor $1/n$ times while the center of the inner rotor makes one revolution around the circle,

where E denotes an amount of eccentricity between the inner rotor and the outer rotor,

t denotes a maximum clearance between addenda of the outer rotor and the inner rotor pressed against the outer rotor, and

n denotes the number of teeth of the inner rotor.

* * * * *